Work Orde	er ID 75	573			*755	70*			1	-	at .		Page 1	=
October-25-11	3:07:10 PM				/ n:	ר. / נ			Noi	1- 8	317		1 age 1	
Item ID: Revision ID:	D3324-041				Accept	*N900	040	100	1	Setup			S1*	
Item Name:	Basket Base A	Assembly									Stop	×Ν	S2*	
Start Date:	25/10/2011	Start Qty: 1.0		*1*		Cust Item I	D:							
Required Date:	08/11/2011	Req'd Qty: 1.0	0	*1*		Customer:								
Reference:										_	~			
Approvals:	Process Pla	an: M.C.J	Date:	11110/25	Tooling:	Da	ate:	_		Run	Start	*N	R1*	
					SPC (Y/N):	Da	ate:				Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt	-	Reject Number	Insp. Stamp	
Draw Nbr	Rev	vision Nbr												-
D3324	Rev	/ B												
100			-lg		0.00					1.1				
100. Large Fab		Large Fab Memo			0.00			. *	A		///	0/0	3 (x	$\Big)$
Large Fab		1-Cut to Qty 3 4 2 2 10	D3324-1 D3324-3 D3324-5 D3324-7 D3324-9	Description Bottom Tube Full Length Tub Top End Tube Bottom EndTul	Batch M/09127 BE M/09127 BE M/09127 BE M/09127							·		
		2- Welc A/R 4	l as per dwg 130 rod batch;	41000	75									
*110 *110*		QC9- Inspect visual	per QSI004- Fu	usion Welds	0.00				ŗ	ı.		BE.	1/11/01	7
QC Quality Control		Memo		·	0.00				_/	6	/		1-1-01	

W/O:			W	ORK ORDER CHANG	ES				
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Ye	s No	DQA:	_ Date: _	
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NCR:			WORK ORD	ER NON-CONFORMA	NCE (NO	CR)			
DATE	STEP	Description of NC		Corrective Action Secti		Ve	rification	Approval	Approval
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Work Orde October-25-11 .		573		*755	573*					Page 2
Item ID: Revision ID:	D3324-041			Accept	*N900	040	100)* s	etup Start	*NS1*
Item Name: Start Date: Required Date: Reference:	Basket Base A: 25/10/2011 08/11/2011	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:			Stop	*NS2*
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		nte:		R	un Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II)	Operation Description QC5- Inspect part compl	eteness to step on W/O	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty		Reject Insp. Number Stamp
120 QC Quality Control		Memo		0.00				M		11-040
121 *1 21		Pressure Wash per QSI00	05 4.3	0.00			ſ	Y /X	m 1	
HandFinish		Memo		0.00			l	1- <i>Y</i> -	1444	AHH 104

Memo

Hand Finishing

	Pa									
W/O:			WO	RK ORDER CHA	NGES					
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Part No		PAR #:	Fault Categ	gory:	NCR	: Yes N	o DQ	A:	_ Date: _	
	Re	esolution:	_ Disposition	າ:	QA:	N/C Clos	sed:		Date:	
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D.4.T.E.	0755	Description of NC		Corrective Action	Section B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	ion	Sign & Date		on C	Chief Eng	QC Inspector
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Work Ord October-25-11		573		*75!	573*						Page 3
Item ID: Revision ID:	D3324-041			Accept	*N9000	4010	ገ በ *	Setup	Start	*N:	S1*
Item Name:	Basket Base A	Assembly							Stop	*N:	S2*
Start Date: Required Date Reference:	25/10/2011 e: 08/11/2011	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:						
Approvals:	Process Pla	an:	Date:	Tooling:	Date:			Run	Start	*NI	R1*
	QC:		Date:	SPC (Y/N):	Date:				Stop	*NI	R2*
Sequence ID/ Work Center 1	ID	Operation Description White Gloss(Ref: 4.3.5.1)) per OSI005 4 3-Alum	Set Up/ Run Hours	Tool ID T	Tool # Pla Coo		pt Re Qt	-	Reject Number	Insp. Stamp
130 Powdercoat	1120	Memo	12-0	0.00			lX4	L 1	Nef	<u> </u>	/4/04
Powder Coating	40	START TIN	1E: 2nd coat if necessary***	30 + 215					÷	,	
140		QC3- Inspect Part Finish	. 400	0.00				/			
*14 0 *		Memo	·	0.00			M		/) -	_1)	-040

Quality Control

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DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Description	ion B		cation ion C	Approval Chief Eng	Approval QC Inspector
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Work Orde		573		*755	573*							Page 4
Item ID: Revision ID: Item Name:	D3324-041 Basket Base A	ssembly		Accept	*N900	040	100)* 5	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	25/10/2011 08/11/2011	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*	·	Cust Item II Customer:	D:						
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		te:		I		Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 150 *150* Packaging Packaging		Operation Description Identify as per dwg & St Memo	ock Location: <u>GA</u> w (0 75570	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept	Reje Qty		Reject Number	Insp. Stamp
*160 *160* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00					-		M/11 11-07	17)

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W/O:			WO	RK ORDER CHANG	GES					
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Picklist Print

October-25-11 3:07:16 PM

Work Order ID: 75573

75573

Parent Item: D3324-041 *D3324-041*

Parent Item Name: Basket Base Assembly

Start Date: 25/10/2011

Required Date: 08/11/2011

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A05.02.09New issueKJ/JLM

IPP Rev: B 08-12-16 attach DEO DD verified by: EC

Component Item ID Item Name	P/ Replacement Item ID	t Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3328-3 *\(\begin{align*} \begin{align*} ali	3*	Manufactured	No			100	Each	24.0000	**		111,	0/21	,
				Location WA005	33872	Loc	<u>Oty</u> 24 24	Loc Code		Ω_{i}	-		
D3348-1 *D3348-	1*	Manufactured	No		33072	100	Each	5.0000	4 **	4 Jy	1////	03,	1
				Location WA005	44246	Loc	Oty 5 5	Loc Code		37	15575 -	4,	יע י
D3349-3 *D3349- Spacer Bushing	3*	Manufactured	No			100	Each	10.0000	2 **	2	J 111	ıola	طا
,				<u>Location</u> WA	72930	Loc	Otv 10 10	Loc Code	7	<u> </u>	_		
D3367-1 *D3367- Mounting Bracket	1*	Manufactured	No			100	Each	20.0000	**		Y	110/3	۵۵
				Location WA005	43228	Loc	Qty 20 20	Loc Code		(AX)	_		

W/O:			WC	RK ORDER CHANG	ES	· · · · · · · · · · · · · · · · · · ·		
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Part No	·	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:	Date: _	
		solution:						
NCR:		1	WORK ORDI	ER NON-CONFORMA	ANCE (NCR)		
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Picklist Print October-25-11 3:07:16 PM Work Order ID: 75573 *75573* Parent Item: D3324-041 *D3324-041* Parent Item Name: Basket Base Assembly Start Date: 25/10/2011 Required Date: 08/11/2011 Start Qty: 1.00 Required Qty: 1.00 M4130NTS0.500W.035 Purchased No 100 f 270.9988 46.6 49.05263 *M4130NTS0 500W 035* ** 4130 Square tube .500 x .500 x .035w Location Loc Oty Loc Code **MAT034** 270.9988 5.8 + 2.9 END BAR SCRAP 109127

109385

112786

M569FX0 50-18F 569 Expanded Metal

Purchased

No

M569EX0.50-18F

Location Loc Qty Loc Code MAT018 78 112776 10 117806 119226 64

100

216

sf

78.0000

28

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15.75

39.2488

Page 2

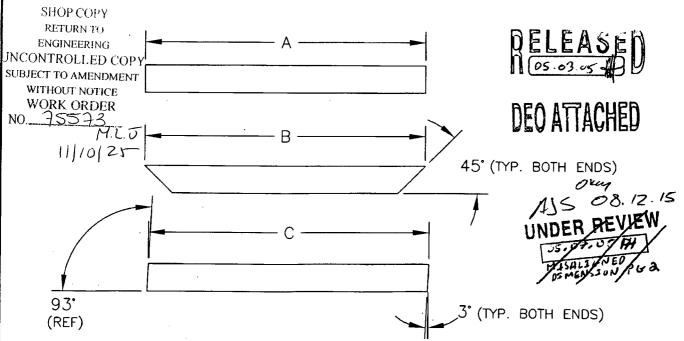
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DATE	STEP	Description of NC		·	ection B	Verifi	cation	Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector	
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DESIG		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	•
CHECH	KED,/	APPROVED	DRAWING NO. RE	V. B
	#	#	D3324 SHEET 1	0F 3
DATE	· · · · · · · · · · · · · · · · · · ·		TITLE S	CALE
05.0	3.04		BASKET BASE ASSEMBLY	NTS
Α		04.10.20	NEW ISSUE	
В		05.03.04	UPDATE MESH MATERIAL SPEC	

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET



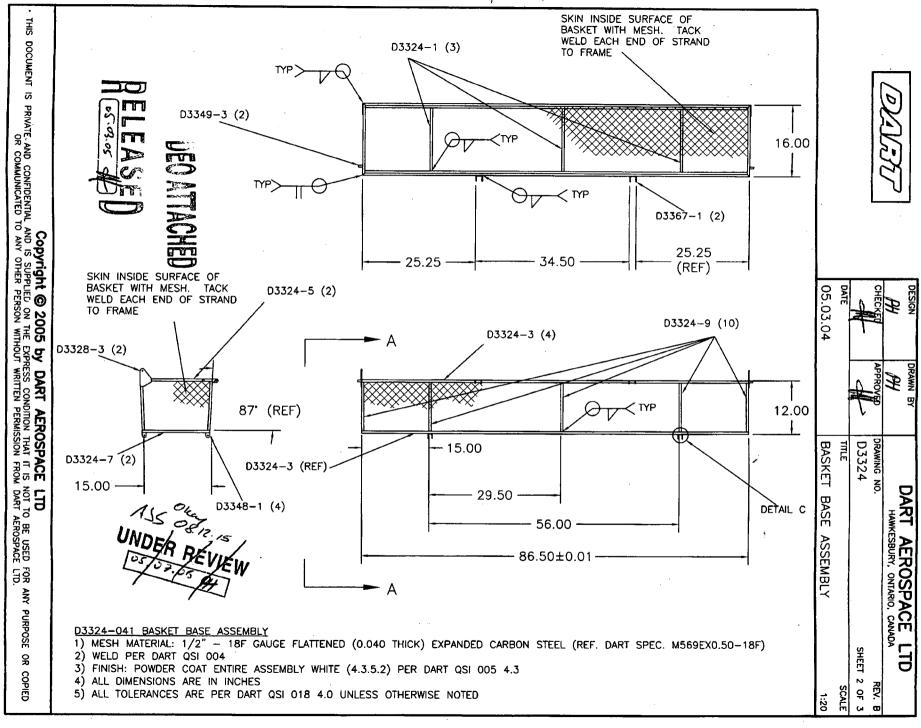
D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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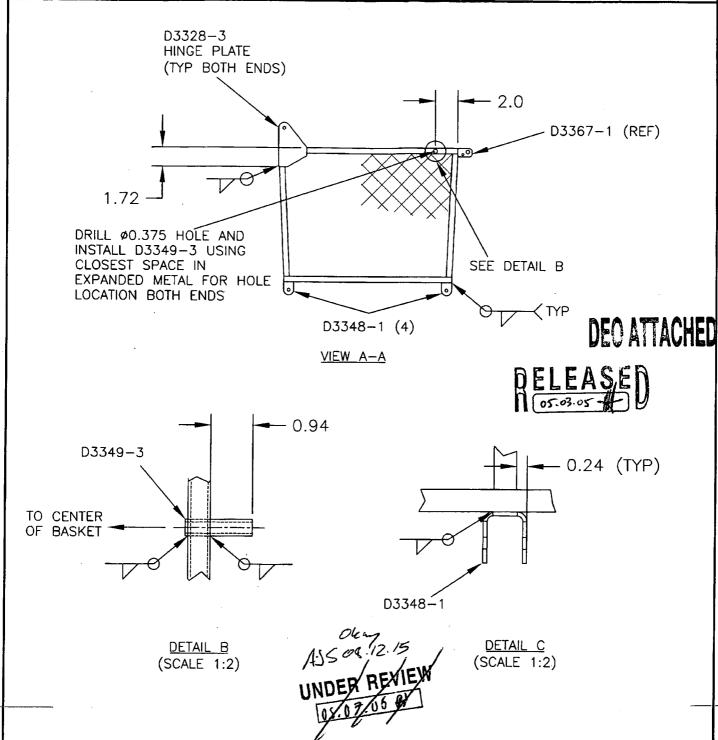
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DATE	STEP	Description of NC Section A	Initial	Action Description	stion B Sign	1& Sect	cation tion C		Approval QC Inspector
			Chief Eng	Chief Eng	Da	le			



DESIGN DRAWN BY DART AEROSPACE LTD PH HAWKESBURY, ONTARIO, CANADA CHECKE DRAWING NO. REV. B D3324 SHEET 3 OF 3 DATE TITLE SCALE 05.03.04 BASKET BASE ASSEMBLY 1:8



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W/O:		PART	V	ORK ORDER CHAN	GES					-
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D3324	BASKET BASE ASSEMBLY		ING ORDER		B-1	SHEET 1 OF 1	NTS
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Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____

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